

Date: Thursday, 22/01/2009 8:01:17 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	AFT ADJUSTABLE BLADE SUPPORT ASSY
<b>Job Number</b> :	45042		
<b>Estimate Number</b> :	13436		
<b>P.O. Number</b> :		<b>Part Number</b> :	PB674300113
<b>This Issue</b> :	22/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	B6743001 P.8
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43060	<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	28/01/2009
<b>Written By</b> :		<b>Qty:</b>	9
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	<u>MF 09-01-22</u>		
<b>Comment</b> :	Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PB6743001255	Inner Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube

batch: 44981.MF 09-02-18

2.0	PB6743001249	Inner Tube Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube Bushing

batch: 341877MF 09-02-18

3.0	PB6743001253	Gusset
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B41492.MF 09-02-18

4.0	PB6743001254	Gusset
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B41493MF 09-02-18

5.0	PB674300167	PB67-43001-67
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

PB67-43001-67

batch: B45022.MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45042

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

SP 09-02-23. (9x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09/02/23 (9x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23 (x9)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

HELICAL INSERT

M1 7935 x 2, M110768 x 7

09-02-18 MF

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

CP 09-02-24

(x9)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 (x9)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m 18/44

(9)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

FL 09/03/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45042

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

3:25

OVEN TEMPERATURE:

320°

FINISH TIME:

3:55

FL 09/03/03 (9)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 09/03/07 (9x)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)  
90 Degree Cover Plate  
batch: 415762

MF 09-03-09

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)  
PB67-43001-83  
batch: 415072

MF 09-03-09

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 72.0000 Each(s)  
Screw  
batch: 110704

MF 09-03-05

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 72.0000 Each(s)  
WASHER  
batch: 110704

MF 09-03-05

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- match drill cover to existing holes in support
- 2- assemble as per dwg

SAD 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45042

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*20903-09 (9)*



21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*



*SAD 09-03-09(9)*

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



*09/03/10 H*

Job Completion



*MF 09-03-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



